

**ABSTRACT OF THE DISCLOSURE**

A winding pattern and technique for a stator of an electric motor is provided. The pattern is particularly well-suited for forming a four-pole, three-phase machine. The winding pattern permits concentric windings to be fully installed in slots of a stator core by machine in multiple steps. The concentric windings include windings which are singularly located within slots, and windings that share slots with other windings. The windings maybe inserted in the core slots by rotation of the core in an insertion station. Leads from the windings exit both ends of the core to facilitate channeling and termination of the windings.

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